

**\*85955\***

Page 1

**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

9  
~~\*6\*~~  
 \*6\*

**Start Date:** 19/06/2012      **Start Qty:** 6.00

**Cust Item ID:**

**Required Date:** 03/07/2012      **Req'd Qty:** 6.00

**Customer:**

**Reference:**

Approvals: Process Plan: MLJ

**Date:** 17/06/19

### Tooling:

**Date:**

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):****Date:**

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3290	Rev C								
150~ <b>*150*</b> Packaging Packaging	Pick Kit  <b>Memo</b>	0.00  0.00				(4)	SAD	12-09-13	
160 <b>*160*</b> Small Fab Small Fab	Small Fab  <b>Memo</b> Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap	0.00  0.00				4	SAD	12-09-13	
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  <b>Memo</b>	0.00  0.00							SMB / DAS 12-9-13 12/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 85955

**\*85955\***

Page 2

June-19-12 8:03:46 AM

Item ID: D3290-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Window Assembly

Stop

**\*NS2\***

Start Date: 19/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location: 219

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

4 82 12/9/14

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/9/18 10

112-09217

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-19-12 8:03:51 AM

Page 1

Work Order ID: 85955

\*85955\*

Parent Item: D3290-041

\*D3290-041\*

Parent Item Name: Replacement Window Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP B05.05.25Added Step 11KJ/JLM

IPP C06.05.09Ecn 798 EC

IPP Rev:D Now on Waterjet 06-06-16 JLM

IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2126		Manufactured	No			160	f	235.2603	6.5	39			
-------	--	--------------	----	--	--	-----	---	----------	-----	----	--	--	--

\*D2126\*

Seal

\*\*

SAD 12-09-13

### Location

### Loc Qty

### Loc Code

ST405

235.26029

57106

4

68336

2.44679

76094

228.8135

26

(D2126-0780) cut qty (1) at 78.00" as per dwg

\*\*\*per kit\*\*\*

D3290-3		Manufactured	No			160	Each	8.0000	1	6			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D3290-3\*

Window

\*\*

SAD 12-09-13

### Location

### Loc Qty

### Loc Code

ST221

8

75052

7

81498

1

4

D3290-1

frame

Batch: 82838

4

6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

FWD  
INBOARD

D2126-0780 LOCKING SEAL  
(TRIM TO FIT)  
D3290-1 WINDOW FRAME  
D3290-3 WINDOW

1.10 (TYP)  
DIST. FROM FRAME  
EDGE TO WINDOW

D2126-0780 LOCKING SEAL  
(REF)

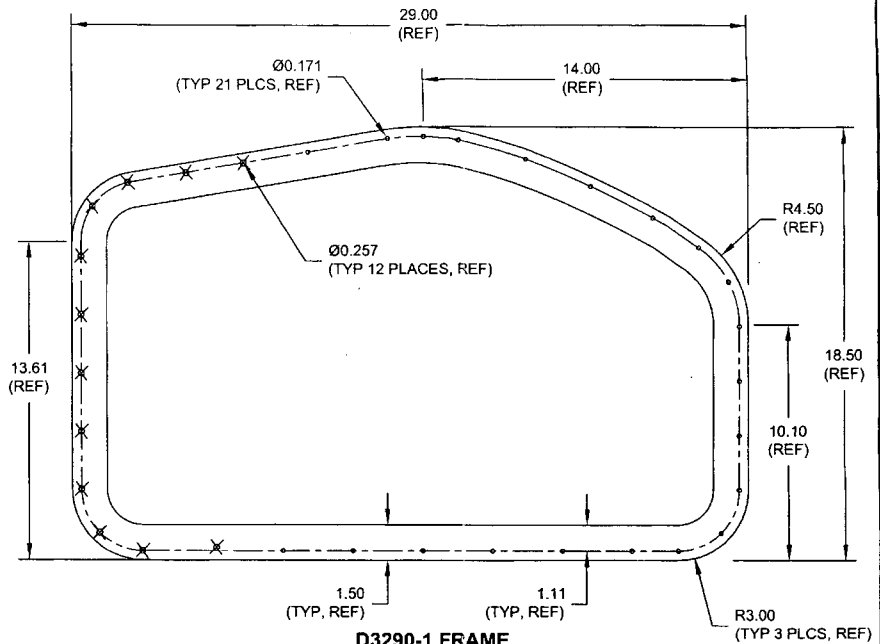
ENSURE D3290-3 WINDOW IS INSTALLED  
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

SECTION A-A  
NTS

### D3290-041 REPLACEMENT WINDOW ASSEMBLY

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

**GENERAL NOTES:**  
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED



### D3290-1 FRAME

#### D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

**RELEASED**  
07.07.22  
**DEO ATTACHED**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO: 85955  
MLJ  
12/06/19

**UNDER REVIEW**

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290  
REV. C  
SHEET 1 OF 2

TITLE  
REPLACEMENT WINDOW ASSEMBLY  
SCALE 1:5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

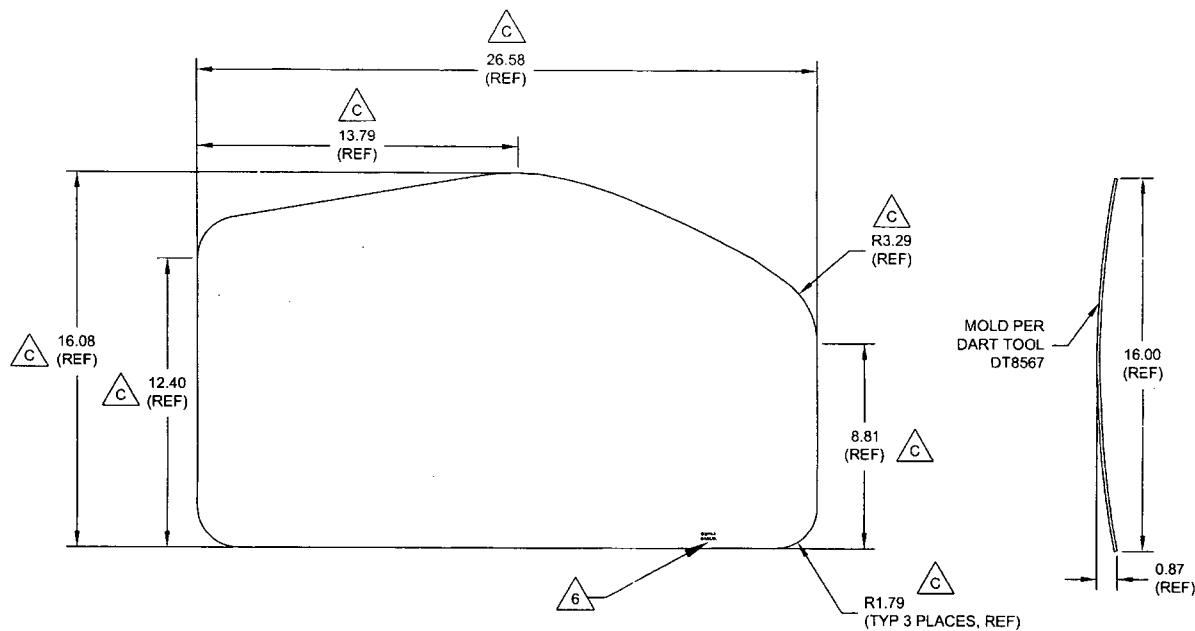
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





### D3290-3 WINDOW

#### D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED  
RELEASED  
07.07.22

DESIGN	<del>3</del>	DART AEROSPACE LTD	
DRAWN	<del>3</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>3</del>	DRAWING NO.	REV. C
MFG. APPR.	<del>3</del>	D3290	SHEET 2 OF 2
APPROVED	<del>3</del>	TITLE	SCALE
DE APPR.	<del>3</del>	REPLACEMENT WINDOW ASSEMBLY 1:	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>GP</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

**PURPOSE:**

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

**CHANGE:**

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

**D3290-1 NOTES**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)  
 OR  
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/8 OR AMS 4016  
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

**RELEASED**  
 2009-10-09  
*MD*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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